Work Order ID 65303 - 2

January 11, 2011 9:21:10 AM

Item ID:

D3315-4

Revision ID:

Item Name: Wearplate

Required Date: 1/31/11

Start Date:

1/18/11

Start Oty: 6.0

Reg'd Otyx 6.00

Accept



Setup Start

Cust Item ID:

Customer:

Approvals:

Reference:

Process Plan:

Month

Date: //- 6 - 1 F

Tooling:

Date: Date: Start Stop

Stop



OC:

Date:

SPC (Y/N):

Tool# Plan

Accept

Reject

Run

Reject

Insp.

Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Code

Otv

Qty

1211-2-14

Number

Stamp

Draw Nbr

Sequence ID/

Revision Nbr

D3315

Rev B

100

FLOW WATER JET

Waterjet

FLOW CNC Waterjet

1010 - 163

Memo

1-Cut as per Dwg 1)3315

0.00

Prog Rev: R

Deburr if necessary

110

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

1811-3-14

120

Quality Control

QC8- Inspect parts - second check

Memo

Memo

0.00

Dart Aerospace Ltd WORK ORDER CHANGES W/O: Approval Approval PROCEDURE CHANGE DATE STEP Bv Date Qtv Chief Eng / QC Inspector Prod Mar Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Verification Description of NC Approval Approval DATE STEP Sign & **Action Description** Initial QC Inspector Section A Section C Chief Eng Date Chief Eng Chief Eng

Work Order ID 65303

January 11, 2011 9:21:11 AM

Item ID: Revision ID: D3315-4

Wearplate

Item Name: Start Date:

1/18/11

OC:

Start Oty: 6.00

Required Date: 1/31/11

Reg'd Otv: 6.00



Accept

Setup Start



Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date: Date: Run

Start

Stop



Sequence ID/ Work Center ID

130

Brake NC

Brake NC

Operation Description

0.00

Set Up/ Run Hours Tool ID

Cust Item ID:

Customer:

Tool# Plan Code

Accept Otv

(6

Reject Oty

Reject Number

Insp. Stamp

NC BRAKE

0.00

Form using DT8179 Die and DT8157 as per Dwg D3315 Rev:

140

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

150

Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Weld hard surface using D3315-4T3 as per QSI 004 and Dwg D3315 Rev. Part Number Description

N/A

7560 Hardcoat Rod

@ 11-2-23

W/O:			W	ORK ORDER CHANGE	S			
DATE STEP		PROCEDURE CHANGE			Ву	Date Qt	y Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA: _	Date: _	
	Re	solution:	Disposition	on:	QA: N/C C	osed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	₹)		
		Description of NC		Corrective Action Section	n B	Verification	n Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section C	Chief Eng	QC Inspecto
		8						
	1							

Work Order ID 65303

January 11, 2011 9:21:11 AM

Item ID:

D3315-4

Revision ID:

Item Name:

Wearplate

Start Date: 1/18/11

Required Date: 1/31/11

OC:

Start Oty: 6.00 Reg'd Oty: 6.00



Accept



Setup Start





Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop



Sequence ID/ Work Center ID

160

170

180

Operation

QC10- Inspect visual per QS1004- ground welds

Description

Memo

Set Up/

Run Hours

Tool ID

Tool# Plan Code

Accept Otv

Reject Oty

Reject Number

Insp. Stamp

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 Sulex 125

0.00

82/2010

Quality Control

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

Memo

X m. 1 11/03/01

Dart Aerospace Ltd W/O: WORK ORDER CHANGES Approval Approval QC Inspector DATE STEP PROCEDURE CHANGE Bv Date Qtv Chief Eng / Prod Mgr Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: Date: Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR:

		Description of NC		Corrective Action Section E	Verification	Anneousl	Anneoval	
DATE	STEP	Section A	Initial Action Description Sign Chief Eng Chief Eng Date			Section C	Approval Chief Eng	Approval QC Inspecto
								(iii
NOTE: D	ate & initia	I all entries						

Page 4

Work Order ID 65303

January 11, 2011 9:21:14 AM



Item ID:

D3315-4

Accept

Setup Start

Stop

Revision ID:

Item Name:

Start Date:

Wearplate

1/18/11

QC:

Start Qty: 6.00 Req'd Qty: 6.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Required Date: 1/31/11

Process Plan:

Date: Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date:

Start Run

Stop

Plan

Code

Sequence ID/ Work Center ID

190

Quality Control

Operation Description

Packaging

QC3- Inspect Part Finish

Memo

0.00

0.00

Tool#

Date:

Accept Qty

Reject Oty

Reject Number Stamp

Insp.

200

Packaging Packaging

Memo

0.00

0.00

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3315-4. B/N:

BXXXXX | For Product/Eligibility see PDA04-17 and Stock | Location:

210

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Dart	Aerospace	Ltd

W/O:			W	ORK ORDER CHANGI	ES					
DATE	STEP	PRO	CEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	egory:	NCF	R: Yes 1	lo DQ	A:	Date:	
	R	esolution:	Disposition	on:	QA:	N/C Clo	sed:		Date:	
NCR:		V	VORK ORD	ER NON-CONFORMA	NCE	(NCR)				
				Corrective Action Section	on B	Ve		fication	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng			Sign & Date	& Section C			
							-			

Picklist Print

January 11, 2011 9:21:10 AM

Work Order ID: 65303

Parent Item:

D3315-4

Parent Item Name: Wearplate



Start Date: 1/18/11

Required Date: 1/31/11

Start Qty: 6.00

Required Qty: 6.00

Date

Issued

Comments:

IPP: A 05.05.12 New issue KJ/JLM IPP Rev:B As per Rev B 06-03-24 JLM

IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name

Replacement Mfg/ Item ID Purch Bin Primary Item Location Last Location

Route Seq ID

Unit of Measure Hand

sf

Qty per Kit Total Qty on

Qty

Issued

Qty

Status

M1010S16GA

Purchased

No

100

13.9250

2.296

14.50105

B11-2-14

1010/1025 sheet 16GA

Location MAT19

111410

Loc Qty 13.925 13.925 Loc Code

115791

116791

Dart Aerospace Ltd W/O: WORK ORDER CHANGES Approval Approval PROCEDURE CHANGE DATE STEP By Qtv Date Chief Eng / OC Inspector Prod Mar Part No: ______ PAR #: _____ Fault Category: ______ NCR: Yes No DQA: ____ Date: ____ Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____ WORK ORDER NON-CONFORMANCE (NCR) NCR: Corrective Action Section B Description of NC Verification Approval Approval STEP DATE Sign & Initial **Action Description** QC Inspector Section A Section C Chief Ena Date Chief Eng Chief Eng

DART AEROSPACE LTD	Work Order:	65 30%
Description: Wearplate	Part Number:	D3315-4
Inspection Dwg: D3315 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

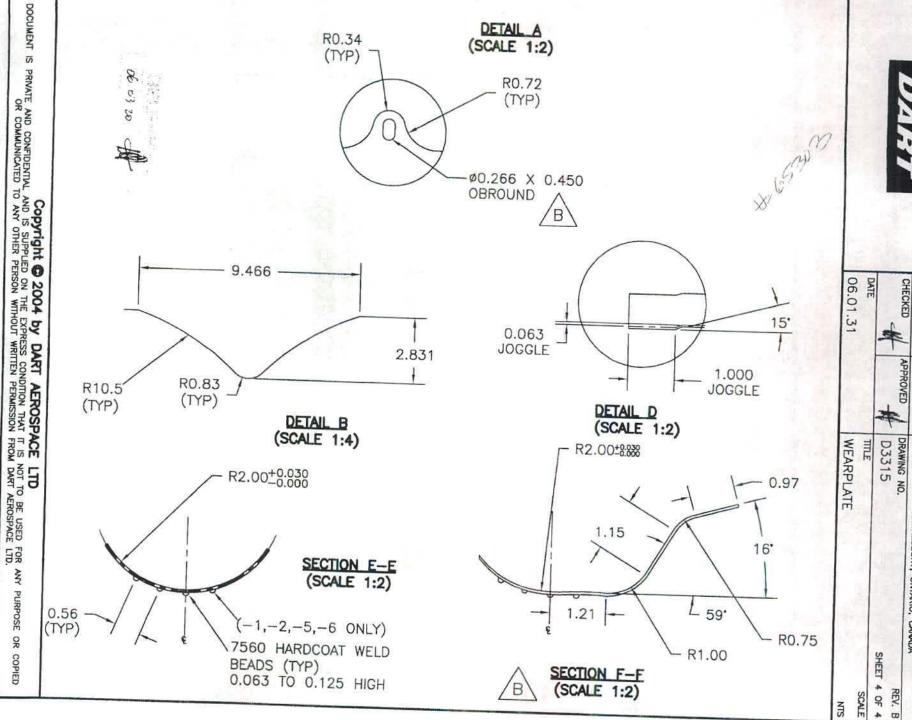
	F	
X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.214	+/-0.010	CIEZ	Þ		V 1802	
4.402	+/-0.010	4400	d		V	
62.75	+/-0.030	62.75	y.		T 1801	
58.094	+/-0.010	58,100	>		7	
Ø0.266 x Ø0.450	+0.006/-0.001	369 x 486	>		V	
Ø0.300	+0.006/-0.001	-305	<i>y</i>		V	
1.62	+/-0.030	1,635	<u>`</u> _		U	
5.375	+/-0.010	5,371	y		V	
10.594	+/-0.010	10.394	2		i i	
18.875	+/-0.010	19.675	-		7	
0.063	+/-0.010	1059	7		¥	
						69

Meas	ured by:	13	Audited by:	8	Prototype	Approval:	N/A
Date: 11-2-14		Date: 1102/14		Date:		N/A	
Rev	Date	Change		196 0	Re	vised by	Approved
Α	07.10.09	New Issue			KJ	Vised by	F

418

RT AEROSPACE LTD



THIS